Work Order ID 59625 ٠ Page 1 Wednesday, June 09, 2010 8:42:02 AM Item ID: D3536-25 Accept Setup Start **Revision ID:** Stop Item Name: Gasket **Start Date:** 6/9/2010 **Start Qty: 20.00 Cust Item ID: Required Date: 6/17/2010** Req'd Oty: 20.00 **Customer:** Reference: Run Start Date: 10-6-07 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code **Qty** Number Stamp **Draw Nbr Revision Nbr** D3536 Rev A 100 0.00 FLOW WATER JET 1B 10-6-24 Waterjet 0.00 Memo FLOW CNC Wateriet □Prog Rev: □2-1-Cut as per Dwg D3536 □Dwg Rev: Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B10-6-24 0.00 Memo Quality Control 120 QC8- Inspect parts - second check Memo Quality Control

m, .

Dart Ae	rospace L	td							τ
W/O:			WC	ORK ORDER CHANGES	\$			<u> </u>	
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
Part No	:	PAR #:	Fault Cated	gory:	NCR: Yes	No. DOA:		Date	
				1:					
NCR:				ER NON-CONFORMAN					
DATE	0750	Description of NC	Corrective Action Section I		В	Verificat		A	Approve
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approva QC Inspect
				· · · · · · ·					

Work Order ID 59625

Wednesday, June 09, 2010 8:42:02 AM



Page 2

Item ID:

D3536-25

Accept



Setup Start



Revision ID:

Item Name:

Start Date:

6/9/2010 Required Date: 6/17/2010

Start Qty: 20.00

Cust Item ID: Customer:

Reference:

A	OD	ro	va	ıs:

Sequence ID/

Work Center ID

Process Plan:

Date:

Tooling:

Date:

Run

Reject

Qty

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

Tool # Plan

Code

Accept Qty

Reject

Insp. Number Stamp

130

Packaging

Packaging

Memo

Operation

Description

Identify as per dwg & Stock Location:

0.00

0.00

140

OC

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

10/06/28×

Gasket

Req'd Qty: 20.00

Dart Ae	rospace	Ltd								•
W/O:			WC	RK ORDER CHAN	IGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvi
									·	
		*								
Part No):	PAR #:	Fault Cate	jory:	NCR	:Yes N	lo DQA:		_ Date: _	
	Re	esolution:	Disposition):	QA:	N/C Clo	sed:	·	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCR)				-
DATE	STEP	Description of NC		Corrective Action S	ection B		Verificat		Approval	Annrova
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Section		Chief Eng	Approva QC Inspect
:										
		,								
									,	

Picklist Print

Wednesday, June 09, 2010 8:42:06 AM

Work Order ID: 59625

Parent Item:

Comments:

D3536-25

Parent Item Name: Gasket

IPP Rev:A

New Issue 07-02-14 JLM

Start Date: 6/9/2010

Required Date: 6/17/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No		100	sf	392.9531	0.5956	12.53895	8.	<u> </u>	·
										Q . a-	1-14	

NEOPRENE SHEET 0.063

Location	Loc Oty	Loc Code
MAT	287.7	
114691	287.7	
MAT052	105.2531	
114176	105.2531	



Dart Aerospace Ltd	d
---------------------------	---

W/O:			V	VORK ORDER CH	ANGES	7				
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:									

Part No	:	PAR #:	_ Fault Ca	tegory:	NC	R: Yes 1	lo DQA:	<u> </u>	Date:	
	R	esolution:	_ Disposit	ion:	QA	N/C Clo	sed:	ļ	Date: _	
NCR:		W	ORK OR	DER NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &	Verifica		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	1_	Chief Eng	QC Inspector
								<u> </u>		

DART AEROSPACE LTD	Work Order:	59625
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.86	V			
16.35	+/-0.030	16.35	V			
10.90	+/-0.030	10,90	حو			
5.45	+/-0.030	5,45	>			
6.00	+/-0.030	6.00	7			
6.75	+/-0.030	6.75	7			
12.75	+/-0.030	12.75	7			
1.89	+/-0.030	1.892	*			
0.30	+/-0.030	.301	*			
0.30	+/-0.030	, २९५	7			
Ø0.19	+0.005/-0.001	091,	ъ			-10.00

Measured by:	R	Audited by:	Prototype Approval:	N/A
Date:	10-6-24	Date: (0/06/24)	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM	R
			717	

rospace Ltd								
		WO	RK ORDER CHANG	ES			•	
STEP	PR	PROCEDURE CHANGE By Date Qty Chi						
Resolut	ioh:	Disposition	_ QA: N/C C	A: N/C Closed: Date:				
		WORK ORDE	R NON-CONFORMA	NCE (NC	₹)			
CTED	Description of NC	Corrective Action		on B	Varification		Annuoval	Approva
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		& Section		Chief Eng	QC Inspect
						<u> </u>		
	STEP	STEP PR PR PAR #: Resolution: STEP Description of NC	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section A Corrective Action Description	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NCF STEP Description of NC Section A Section B Sign of Section B Sign of Section A Section B Sign of Section B Section B Section B Section B Sign of Section B Section	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Paction of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: _ Resolution: Disposition: QA: N/C Closed: Date: _ WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

B

DART

AEROSPACE PORT HADLOCK,

USA

 \mathcal{E}

DRAWING NO.

SHEET 1 OF 6

9

. 0 .25

GASKET

06.10.25

NEW ISSUE

20.02.12

SHOP COPY RETURN (O **ENGINEERING** UNCONTROLLED COLY SUBJECT TO AMENDMEND WITHOUT NOT CE

WORK ORDER NO. 59625 RAJO-6-09

26.65
23.15
21.15
17.65 13.40 9.15
1.89
DETAIL A - - 8.00 - 3.90 - 14.00 - 14.00 -

D3536-11 GASKET

32.90	
29.40	
27.40	
23.90	
18.98	
14.07	
9.15	0.90
5.65	
	.l i
	1.89
DETAIL A - 3.90	'
(TYP 4 PLS) 20.00	
(TYP 4 PLS) 20.00	

D3536-13 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

ေ	
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPIACE USA, INC.	
Ç≱	
ŠΩ	
	Ω
0 ≥	ş
₹ 8	疲
	롰
RPP	O N
SSE	ğ
¥2.	9
ձ볶	₹ -
⊐p ₹₽	¥
	7
₽ ₽	right © 2006 by DART AEROSPACE USA, INC.
	g
SSO	ጀ
고 국	m
Ĩ,	S
N N	>
A T	중
ROSE PER	?-
AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR AN COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
S E	
Z S	
"₹	

PURPOSE

욹 COPIED

봀

DOCUMENT

ᄶ

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Chief Eng / DATE STEP **Approval PROCEDURE CHANGE** By Date **Q**tv QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval** Approval Initial **Action Description** Sign & Section A Section d Chief Ena QC Inspector Chief Eng Chief Eng Date

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval DATE **Approval** STEP **PROCEDURE CHANGE** Bv Chief Eng / Prod Mgr Date **D**tv QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: _____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Sign & Initial **Action Description** Section A Section (Chief Ena QC Inspector Chief Eng Chief Eng Date



06.10.25 GASKET

57.02.12 23.14 -17.75 DETAIL A 4.75 -2.00 1.89 6.00 - 16.00 ø0.19 (TYP 6 PLS) - 24.00 32.00 39.00 48.00

52.85

D3536-23 GASKET

DOCUMENT

ᇙ

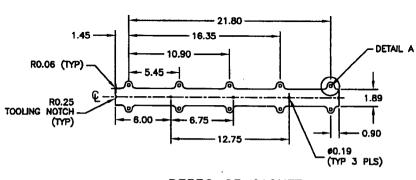
Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

윢

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

Dart Aerospace L	.td
------------------	-----

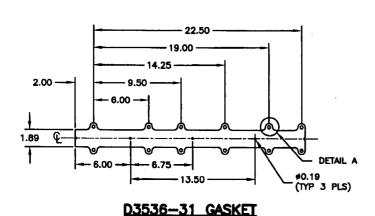
	-										
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE By Date Cty					Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	į										
				. <u>.</u> .						,	
Part No	t No: PAR #: Fault Category: NCR: Yes No DQA: _				:	Date:					
	R	lesolution:	Disposition: QA: N/C Closed:				Date:				
NCR:		\	WORK ORE	DER NON-	CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			ion B	Verificati		ation	Approval	Approval
	JILF	Section A	Initial Chief Eng	Actio	n Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
					,					İ	
											ı

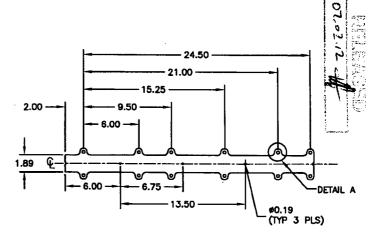
CHECKED 06.10.25 B B (**2**) D3536 GASKET DRAWING NO DART AEROSPACE PORT HADLOCK, ASU,

SHEET 4 OF 6

SCALE 1:10

Z C





D3536-33 GASKET

w/0 59425

MOTES	BLACK NEODBENG	SHEET, 1/16 THICK, 60
I) MAJERIAL:		
	DURUMEIER (REI	F DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

DOCUMENT

ធ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

윘

COPIED

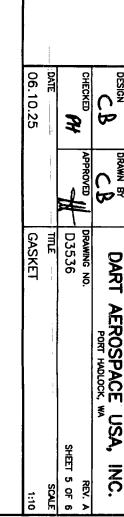
- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

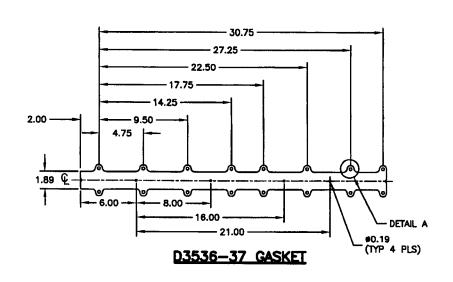
23,25 ———	l
19.75	
17.75	4
14.25 ———	
2.00 - 9.50 -	
4.75	
	4
1.89 €	
	Šadena (
6.00	9 2 PLS)
•	→ DETAIL

D3536-35 GASKET

Dart	Aeros	pace	Ltd
------	--------------	------	-----

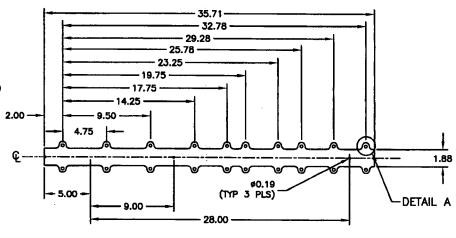
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE				Ву	Date	Oty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:								Date:	
	Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR)					Date:					
NCR:	T		WORK OR			MANCE	(NCH	()			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action	Action S On Description Chief Eng	Section B	Sign & Date		cation tion 0	Approval Chief Eng	Approval QC inspector
NOTE D											





07.02.12

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 DIDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-39 GASKET

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹

COPIED

봀

DOCUMENT

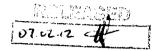
ᄶ

Dart Aerospace Ltd

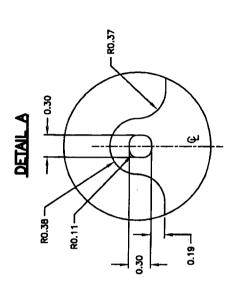
W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE By				qt	y	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				.,,						
Part No		PAR #: Fault Category: NCR: Yes No DQA: _								
	R	esolution:	n: QA: N/C Closed:				Date:			
NCR:		V	VORK ORE	DER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section B			- Cian Verificat		on Approval	Approvai	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Section			Chief Eng	QC Inspector
	·									
-										
					l L					
	L					}				•

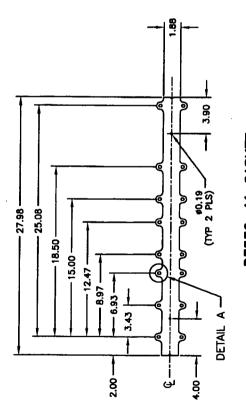


CB CB	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE		TITLE	SCALE
06.10.25		GASKET	1:10









MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M—NEO80—S.063) ALL DIMENSIONS ARE IN INCHES IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ରନ୍ଦ କ 6 3

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:			+								
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Оy	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Cat	_ Fault Category:			No DQA:				
			Disposition:								
NCR:		V	VORK ORE	DER NON-CONFORM	ANCE (NCR					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng		Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector	
				3							
	3	,									
				<u> </u>							
					,						
<u> </u> 											
NOTE	1 0 : :::										